Just Right Carbines Safety and Instruction Manual

The J R Carbine Proudly Made in the USA!

‼ WARNING: Read the instructions and Warnings in this manual CAREFULLY BEFORE using this firearm.

Thank you for your purchase of a J R Carbine. This manual will help you use your Carbine safely.

AMERICAN TACTICAL IMPORTS

Read These Important Requirements and Tips Before Handling or Shooting!

- **READ THIS ENTIRE INSTRUCTION MANUAL.** Prior to removing this firearm from its packaging, and prior to loading and firing, carefully and thoroughly read the entire instruction manual, which gives advice on the firearm's proper handling and functioning. Your safety and that of others (including your family) depends on your responsible compliance with that advice. If unfamiliar with firearms, seek supervised instruction. Firearms safety is your responsibility.

- **THOROUGHLY CLEAN YOUR J R CARBINE BEFORE SHOOTING IT FOR THE FIRST TIME.** In order to ensure maximum function and reliability your Carbine should be lubricated every 100 rounds or between shooting sessions – whichever occurs sooner. **Use Slip 2000 on your firearm.**

- While you may apply a very light coat of gun oil between uses, you MUST be sure to clean and remove any excess oil from inside the action of your Carbine prior to shooting. If you choose to lubricate your Carbine with ordinary gun oil – which is not recommended – you must remove any excess oil from inside the action of your Carbine before, during, and after shooting. Failure to do so can result in excess oil and unburned gunpowder being blown out of the charging handle slot on the side of the receiver opposite the charging handle, potentially causing severe injury to the shooter's face and eyes.

- **USE ONLY HIGH QUALITY AMERICAN AMMUNITION.** This firearm is designed to shoot a wide range of high-quality U.S.-manufactured ammunition. It will also shoot a wide range of foreign manufactured ammunition, but such ammunition can vary widely in quality and consistency. Even American ammunition will vary in the tolerances to which it is manufactured, and some brands and/or types of ammunition will work better in your Carbine than others. Experiment with different brands of ammunition available to you to find the one(s) that perform best in your Carbine. Use of remanufactured ammunition will void the warranty of this firearm.
- **DO NOT USE PLUS-P (+P) AMMUNITION, or any ammunition specified by the manufacturer for use only in handguns or short-barreled firearms.**

!! **USE MAGAZINES MADE BY THE ORIGINAL EQUIPMENT MANUFACTURER (OEM).** This firearm has been designed to use popular OEM pistol magazines. Aftermarket magazines can vary widely from OEM specifications, so they may or may not work well in your Carbine.

!! WARNING

READ THESE INSTRUCTIONS AND WARNINGS CAREFULLY. BE SURE YOU UNDERSTAND THESE INSTRUCTIONS AND WARNINGS BEFORE USING THIS FIREARM.
FAILURE TO READ THESE INSTRUCTIONS AND TO FOLLOW THESE WARNINGS MAY RESULT IN SERIOUS INJURY OR DEATH TO YOU AND OTHERS, AND DAMAGE TO PROPERTY.

Keep this SAFETY & INSTRUCTION MANUAL with this firearm at all times. Transfer it with this firearm upon change of ownership or when presenting it to another person.
You can obtain a copy of the SAFETY & INSTRUCTION MANUAL FREE upon request from:

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YOUR SAFETY RESPONSIBILITIES:

SAFETY IS YOUR NUMBER ONE RESPONSIBILITY!!!!

Your first concern as a firearm owner should be safety, regardless of whether you are in the field, at home, or at the range. Apply the safety rules listed below and throughout this manual in every situation, with any kind of firearm. If you are unsure about any operational aspects of your firearm, please contact ATI at 1-800-290-0065 before proceeding with its operation.

!! **WARNING: YOU MUST FOLLOW ALL OF THESE SAFETY RULES TO ENSURE THE SAFE USE OF YOUR FIREARM. IF YOU FAIL TO FOLLOW THE INSTRUCTIONS AND WARNINGS IN THIS MANUAL YOU COULD CAUSE SERIOUS PERSONAL INJURY OR DEATH TO YOURSELF OR OTHERS, AS WELL AS DAMAGE TO PROPERTY.**

GENERAL OWNERSHIP

- ! **YOU ARE RESPONSIBLE FOR YOUR FIREARM AT ALL TIMES.** In owning a firearm, you must undertake full-time responsibility for your firearm's safety and security. You must protect yourself and all others against injury or death from misuse of your firearm 24 hours a day.

- ! **FIREARM SECURITY IS YOUR RESPONSIBILITY.** You MUST secure firearms safely from children and/or unauthorized users. Always store your firearm unloaded and locked when not in use. Never assume that the use of a lock is sufficient to safely secure your firearm. You must always evaluate your personal situation and employ the security systems that meet your needs and prevent children and unauthorized users from gaining access to your firearm.

- ! **USE YOUR FIREARM ONLY FOR LEGAL PURPOSES.** Legal purposes include target shooting, hunting and lawfully resisting deadly criminal force. You MUST ensure that you are in compliance with all applicable laws and ordinances regarding the use of your firearm.

- ! **ALWAYS SAFELY STORE AND SECURE YOUR FIREARM.** You MUST safely and securely store your firearm. It is one of your most important responsibilities, and it is a full time responsibility. You must always secure

your firearm and ammunition separately so that they are not accessible to children and/or other unauthorized persons.

! **NEVER KEEP AMMUNITION IN THE SAME LOCATION AS THE FIREARM.** Store each in a separate and secure place.

! **NEVER ALLOW A FIREARM TO BE USED BY INDIVIDUALS WHO DO NOT UNDERSTAND ITS SAFE OPERATION OR HAVE NOT READ THESE FIREARM SAFETY RULES.**

! **BE SURE ALL ACCESSORIES, SUCH AS HOLSTERS, GRIPS, SLINGS, SCOPES AND OTHER ACCESSORIES ARE COMPATIBLE** with your firearm and that the accessories do not interfere with safe operation. You MUST understand and follow all of the instructions in this manual, as well as those that may be supplied with your ammunition and any accessory.

! **WARNING: YOU ARE PERSONALLY RESPONSIBLE FOR THE SAFE USE OF YOUR FIREARM. IF YOU FAIL TO FOLLOW ALL OF THESE BASIC SAFETY RULES YOU MAY CAUSE SEVERE PERSONAL INJURY OR DEATH TO YOURSELF OR OTHERS, AS WELL AS DAMAGE TO PROPERTY.** You are the most important safety device when it comes to the use of your firearm and neither ATI nor the manufacturer will be responsible for any personal injury, death or property damage that results from: (1) the criminal or negligent use of this firearm; (2) a disregard of these safety instructions and warnings; (3) improper or careless handling of this firearm; (4) the use of non-standard, defective, improper or reloaded ammunition; or (5) improper or negligent modifications or repairs to this firearm.

SAFE HANDLING

As a firearm owner, you assume a serious and demanding responsibility. The difference between life and death can depend upon how seriously you take this responsibility. There is no excuse for careless or abusive handling of your firearm. Respect the power and potential danger of your firearm at all times.

! **ALWAYS KEEP YOUR FIREARM POINTED IN A SAFE DIRECTION.**
Never point a firearm at anything you do not intend to shoot whether or not it is loaded. This is particularly important when loading, unloading, or field stripping a firearm. ALWAYS control the direction of your firearm.

! **ALWAYS TREAT EVERY FIREARM AS IF IT IS LOADED AND WILL FIRE.** Always personally check for yourself to determine that the firearm is unloaded; do NOT take anyone's word on it. Always lock open the action of your firearm and visually check that it is unloaded before passing it to another person. Always keep your firearm unloaded and safely stored when not using it.

! **NEVER PLACE YOUR FINGER INSIDE THE TRIGGER GUARD OR ON THE TRIGGER UNLESS YOU INTEND TO FIRE.** Ensure that no other objects touch the trigger.

! **NEVER CROSS OBSTACLES SUCH AS FENCES OR STREAMS WITH A LOADED FIREARM.** Always make certain your firearm is unloaded before crossing a fence, climbing a tree, jumping a ditch or negotiating other obstacles.

! **WARNING: DO NOT CARRY THIS CARBINE WITH THE BOLT OPEN AND A LOADED MAGAZINE IN THE CARBINE.** An accidental discharge may result if the bolt closes and the safety lever is not in the "safe" position, leading to death or injury to the shooter or bystanders and damage to property.

! **WARNING: NEVER STRIKE OR DROP THE FIREARM. DOING SO MAY CAUSE A ROUND TO CHAMBER.**

! **WARNING: THIS CARBINE WILL STILL FIRE WITH THE MAGAZINE REMOVED IF A ROUND REMAINS IN THE CHAMBER.** When removing the magazine you must also properly clear the chamber and visually inspect it to ensure that it is clear of any rounds.

! **BE PERSONALLY RESPONSIBLE FOR THE SAFE HANDLING OF YOUR FIREARM AT ALL TIMES.** Firearms are dangerous and can cause serious injury or death if they are misused or used inappropriately. Anyone who owns or handles firearms must make safety their primary consideration. If you violate the rules of safe firearm handling or fail to use common sense you WILL eventually cause an accident. Firearm safety training is available. Contact your firearms dealer, law enforcement agency, local sportsman's club, etc. for availability.

! **NEVER RELY ON MECHANICAL SAFETY FEATURES ALONE.** The only sure way to ensure the safe use of your firearm is to ALWAYS practice safe firearm-handling habits. This is your responsibility.

! **BEFORE HANDLING ANY FIREARM, UNDERSTAND ITS OPERATION.** Not all firearms are the same. Familiarize yourself with the mechanical features of any firearm you intend to use. If you feel uncertain about any operational aspects of your firearm, please contact ATI at 1-800-290-0065 before proceeding with its operation.

MAINTENANCE

! **NEVER DISASSEMBLE YOUR FIREARM** beyond the field stripping procedure outlined in this manual. Improper disassembly or reassembly of your firearm may be dangerous and can lead to serious injury or death.

! **NEVER MANIPULATE, ADJUST OR CHANGE ANY OF THE INTERNAL COMPONENTS OF YOUR FIREARM UNLESS SPECIFICALLY INSTRUCTED TO DO SO IN THIS MANUAL.** Improper manipulation of any components of this firearm beyond the instructions in this manual may affect the safety and reliability of your firearm and may cause serious injury or death.

! **NEVER PERFORM OR ALLOW ANY ALTERATION OR REPLACEMENT OF PARTS IN YOUR FIREARM UNLESS PERFORMED BY A QUALIFIED GUNSMITH USING GENUINE J R CARBINE PARTS.** If you do otherwise, your firearm may function improperly and may cause serious injury or death and damage to property as a result.

! **ALWAYS WEAR EYE PROTECTION THAT IS SPECIFIED FOR USE WITH FIREARMS** every time you handle your firearm for cleaning and maintenance.

SHOOTING

! **ALWAYS BE SURE OF YOUR TARGET AND WHAT IS BEYOND IT.**
Always be sure of where the bullet will strike and shoot only where there is a safe backstop behind your target that will stop your bullet. Be sure that your backstop is free of obstructions, water or other surfaces that can cause ricochets. Remember: Bullets can glance off many surfaces like rocks or the surface of water and travel in unpredictable directions with considerable velocity. Do not fire randomly into the sky.

! **ALWAYS WEAR EYE AND EAR PROTECTORS THAT ARE SPECIFIED FOR USE WITH FIREARMS** every time you discharge your firearm. Make sure others in the vicinity of where you will be shooting do so as well.

! **NEVER USE ALCOHOL OR DRUGS BEFORE OR WHILE SHOOTING.**
Do not use your firearm if you are on any medication that impairs, even slightly, your mental or physical ability.

! **ALWAYS HAVE ADEQUATE VENTILATION.** If you discharge or clean firearms in poorly ventilated areas, or handle ammunition, you may expose yourself and others to lead and other substances known to cause birth defects, reproductive harm, and other serious physical injury. Review the warnings and labels for all ammunition and cleaning products carefully. Wash hands thoroughly after exposure.

! **ALWAYS USE THE CORRECT AMMUNITION FOR YOUR PARTICULAR FIREARM** as indicated by the marking on the firearm. Never use non-standard, reloaded, or "hand loaded" ammunition that has not been subjected to internal ballistic pressure testing.

! **BEWARE OF BARREL OBSTRUCTIONS** Be sure the barrel is clear of obstructions before shooting. Mud, water, snow or other objects may inadvertently lodge in the barrel bore. A small obstruction can cause a dangerous increase in pressure and may damage your firearm and cause injury to yourself and others.

SAFE STORAGE AND TRANSPORTATION

!! **WARNING: FIREARMS ARE DANGEROUS WHEN USED AND STORED IMPROPERLY. THEY POSE A RISK OF SERIOUS OR FATAL INJURIES. FIREARMS CAN BE ESPECIALLY DANGEROUS TO CHILDREN WHEN THEY ARE STORED IN AN IRRESPONSIBLE AND UNSAFE MANNER.** You must keep your firearm locked and unloaded in a secure place for your safety and the safety of others. You should store ammunition in a separate, secure location when it is not in use. Safe and secure storage of your firearm is one of the most important rules of firearm safety. If you fail to follow these rules, you or others may suffer serious injury or death as a result.

! **ALWAYS SECURE YOUR FIREARM IN A MANNER THAT WILL PREVENT UNAUTHORIZED ACCESS.** Keep your firearm unloaded and locked when not in use. Your safety and the safety of others require that you always secure and store your firearm in a manner that will prevent unauthorized access. Never leave a firearm unattended unless it is locked, unloaded and secured.

! **TRIGGER LOCK.** A lock, when properly used, can be an effective tool in preventing unauthorized access to your firearm. There are effective locks and safe storage containers available in the marketplace, which may also be appropriate for your particular needs. Consult your local firearm shop, hardware store, or local police department for guidance on the variety of other safe storage devices or practices which may be appropriate for your particular needs. By purchasing this firearm you have accepted the responsibility of safely securing the firearm at all times and preventing its unauthorized use. Never assume that the use of a lock alone is sufficient to safely secure your firearm. It is your personal responsibility to select and use whatever measures or practices that will enable you to be absolutely certain that your firearm is secure at all times. Never leave the key to a firearm lock with the stored firearm.

!! **WARNING: NEVER LOCK A LOADED FIREARM AND NEVER LOAD A LOCKED FIREARM!**

! **ALWAYS STORE YOUR FIREARM AND AMMUNITION SEPARATELY** so that they are not accessible to children or other unauthorized persons. Safe and secure storage of your firearm and ammunition are your responsibility. It is a full-time responsibility.

! **NEVER ASSUME THAT A "HIDING" PLACE IS A SECURE STORAGE METHOD.** Others may be aware of your storage location or come upon it by chance. It is your personal responsibility to use common sense when storing your firearm and ammunition and to always make sure they are not accessible to children or other unauthorized persons.

! **NEVER TRANSPORT A LOADED FIREARM.** When transporting your firearm, be sure it is unloaded and locked. Safe and secure transportation of your firearm is your responsibility.

! **ALWAYS FOLLOW THE LAW!** Many jurisdictions have laws that make it a crime to keep a firearm unlocked and in an area accessible to children or others. Keeping a firearm locked and unloaded when not in use is not only common sense safety practice... IT IS THE LAW. You must be familiar with all local, state, and federal laws regarding the safe storage and transportation of your firearm. Failure to know and follow the law may result in unauthorized access or use of your firearm by another. Obey all laws relating to the storage and transportation of firearms. Your local police department or firearm shop can furnish you with available information on storing and/or transporting a firearm safely and legally.

! **YOUR FIREARM IS YOUR RESPONSIBILITY.** You must prevent your firearm from being stolen or from being used by untrained or unqualified individuals. Keep it locked, unloaded and secured when not in use.

AMMUNITION

!! **WARNING: NEVER USE AMMUNITION NOT SPECIFICALLY DESIGNATED FOR USE IN YOUR FIREARM. FAILURE TO USE THE CORRECT TYPE OR CALIBER OF AMMUNITION MAY CAUSE THE FIREARM TO JAM, FAIL TO FIRE, OR EVEN GENERATE EXCESSIVE PRESSURE WHICH CAN DAMAGE OR EVEN RUPTURE YOUR FIREARM, CAUSING PERSONAL INJURY, DEATH OR PROPERTY DAMAGE.**

Your J R Carbine is a precision firearm designed to shoot a wide range of high-quality U.S.-manufactured ammunition. It will also shoot a wide range of foreign manufactured ammunition, but such ammunition can vary widely in quality and

consistency. You can expect that your shooting experiences may likewise vary when using such ammunition.

Locate the cartridge designation marked on the firearm. This information indicates the correct ammunition that must be used in this firearm. You are responsible for selecting ammunition that meets industry standards and is appropriate in type and caliber for this firearm.

- ! **NEVER USE A CARTRIDGE NOT SPECIFICALLY DESIGNATED FOR USE IN YOUR FIREARM.** The wrong type of ammunition may exceed the capability of your firearm and may damage or even rupture your firearm.

- ! **NEVER MIX AMMUNITION.** In some cases, a round of ammunition not specified on your firearm may fit into the chamber. Firing ammunition not specified on your firearm may cause it to rupture and cause serious injury or death to you or others.

- ! **ALWAYS INSPECT YOUR AMMUNITION BEFORE USING IT.** Never use dirty, corroded or damaged ammunition which can lead to a burst cartridge which may cause damage to the firearm and personal injury or death.

- ! **USE ONLY COMMERCIALLY MANUFACTURED AMMUNITION** with internal ballistic pressures that are in strict accordance with the specifications of the Sporting Arms and Ammunition Manufacturers' Institute (SAAMI). If you are uncertain, contact your ammunition supplier for verification.

!! **WARNING: NEVER USE NON-STANDARD, RELOADED OR "HANDLOADED" AMMUNITION THAT HAS NOT BEEN SUBJECTED TO INTERNAL BALLISTIC PRESSURE TESTING. RELOADED OR HANDLOADED AMMUNITION MAY HAVE MANY MANUFACTURING AND QUALITY VARIABLES (SUCH AS THE TYPE AND AMOUNT OF GUN POWDER). ANY AMMUNITION THAT IS IMPROPERLY MANUFACTURED, EVEN IN THE SLIGHTEST DEGREE, MAY FAIL TO FIRE OR MAY GENERATE EXCESSIVE INTERNAL PRESSURES WHICH CAN DAMAGE OR EVEN RUPTURE THE FIREARM, CAUSING PERSONAL INJURY OR DEATH TO THE SHOOTER OR THOSE IN THE IMMEDIATE VICINITY.**

A firearm and ammunition are a system and must work together. There are different types of ammunition for different types of firearms. Your firearm has been designed for ammunition of a specific type and a specific gauge or caliber. It is important to select the proper ammunition for your firearm. Different

combinations of bullet velocity, bullet weight and firearm weight can have major impact on felt recoil; high felt recoil could be uncomfortable to some shooters.

! **CAUTION:** Use of ammunition manufactured with corrosive primers in this firearm will cause oxidation to develop on any exposed metal parts of the firearm. To prevent such oxidation, each time ammunition with corrosive primers is used, the residue from the corrosive primers must be completely removed from all exposed metal parts. Conventional oil or solvent-based firearm cleaners WILL NOT dissolve the residue from corrosive primers. Residue from corrosive primers MUST be completely dissolved with a water-based cleaner. After the corrosive residue has been completely dissolved from all exposed metal parts, remove any excess water-based cleaner from the firearm.

! **Lubricate your firearm with Slip 2000, as instructed in this Safety and Instruction Manual. Failure to follow these instructions will cause damage to your firearm and may affect the ability of your firearm to function properly.**

Check with the ammunition manufacturer or a qualified gunsmith if you are unsure whether the particular ammunition you plan to use in this firearm has been manufactured with corrosive primers. If in doubt, follow all the instructions above to prevent oxidation caused by ammunition manufactured with corrosive primers. SAAMI member ammunition manufacturers do not use corrosive primers.

AMMUNITION FAILURES

If your firearm fails to fire when the hammer falls (misfires), keep the firearm pointed in a safe direction, remove your finger from the trigger, and wait 20 - 25 seconds. If your firearm still has not fired, remove the magazine and remove (eject) the cartridge from the chamber and dispose of properly.

If you hear an unusual sound or feel an unusual recoil on firing, stop firing, wait 20 - 25 seconds, remove the magazine, extract any cartridge from the chamber, lock the bolt to the rear, put the safety selector on safe, examine the chamber to ensure it is empty, and examine the bore for obstructions.

! **MAKE SURE YOUR BARREL IS CLEAR AND FREE OF OBSTRUCTIONS.** If you see an obstruction, return your firearm to the Manufacturer or take it to a qualified gunsmith. Never fire a firearm with an obstructed barrel.

If you are unsure or have any concerns, contact your retailer or ATI for advice.

FEATURES OF THE J R CARBINE

Weight:	6 – 6.5 lbs depending on caliber and barrel
Length:	30.125 – 33.5 inches with a standard 16.250 inch barrel
Caliber:	Multi-caliber, interchangeable, 9mm luger, .40 S&W, .45 ACP
Operation:	Semiautomatic blowback
Lubrication:	Dry spray-on gun lubricant
Feeding:	Magazine fed (The J R Carbine utilizes an interchangeable magazine well that allows the use of different brands of magazines)
Finish:	Hard Coat Anodized on Aluminum surfaces, Black Oxide on Steel

COMPONENTS

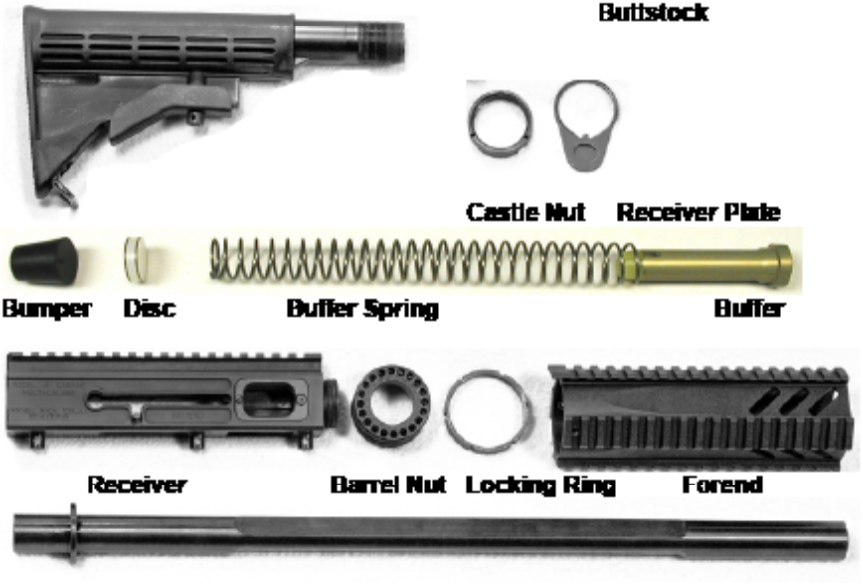

Fig 1.

The J R Carbine is a shoulder-fired, magazine-fed, centerfire pistol cartridge, blow-back operated long gun. It is intended to be fired from a two handed position with the Carbine braced against the shoulder with the buttstock, supported by the nontrigger hand under the forend, and held by the pistol grip with the trigger hand. (See fig 2.)

Fig 2.

(Remember always keep your finger off the trigger with the safety selector on SAFE until you have followed all safety procedures and are ready to fire in a safe responsible manner)

!! **WARNING: PRIOR TO HANDLING YOUR J R CARBINE ENSURE THAT THE SAFETY SELECTOR IS PLACED ON THE "SAFE" POSITION ON THE FIRING ASSEMBLY.** The J R Carbine can be manually cycled by the use of the bolt handle. (See fig 3.) The bolt may be locked to the rear by drawing the handle rearward and rotating it down-ward into the bolt catch. (See fig 3.) The J R Carbine can only be placed on "SAFE" when the hammer is cocked or the bolt is locked to the rear.

Fig 3

UNLOADING

Unloading is accomplished by switching the safety lever from FIRE to SAFE, pulling the bolt handle rearward and locking it into the bolt catch. Pressing the magazine catch button (See fig 4.) will allow the magazine to be removed. Be careful to ensure that the chamber is empty.

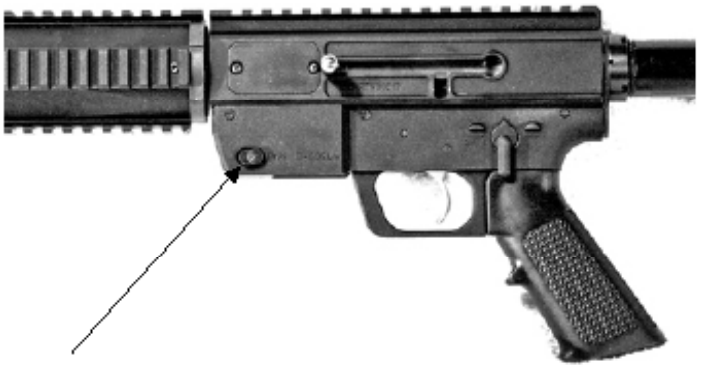

Fig 4.

With the bolt locked to the rear look through the open ejection port to examine the chamber of the barrel to be sure no cartridges are visible and ensure that it is not loaded.

! You must follow this procedure every time a firearm leaves your hand, is cleaned, handed to you or another person, transported or stored.

!! **WARNING: NEVER RELY ON MECHANICAL FEATURES ALONE TO ENSURE SAFETY. ONLY YOUR SAFE FIREARM HANDLING WILL ENSURE THE SAFE USE OF YOUR FIREARM. THIS IS YOUR RESPONSIBILITY.**

LOADING

!! **WARNING: NEVER ATTEMPT TO LOAD THIS FIREARM PRIOR TO CHECKING THE CHAMBER.**

!! **WARNING: ALWAYS LOAD A ROUND INTO THE CHAMBER BY FEEDING IT FROM THE MAGAZINE. NEVER ATTEMPT TO LOAD THE FIREARM BY INSERTING A ROUND INTO THE OPEN EJECTION PORT. FAILURE TO FOLLOW THIS WARNING CAN RESULT IN SEVERE INJURY OR DEATH TO YOUR OR OTHERS.**

You may load the J R Carbine either with the bolt forward and closed, or with it locked to the rear and open.

When loading with the bold closed, insert a loaded magazine up into the magazine well until it clicks. Check to see that it is securely held in place by the magazine catch by pulling down on the magazine; it should stay tightly in place. Pull the bolt handle completely to the rear and then allow the bolt to travel forward and chamber a cartridge. Place the safety selector switch in the SAFE position until you are ready to shoot.

In the event that you chose to load your Carbine with the bolt locked to the rear, FIRST ensure that the safety is switched to the SAFE position. Then insert a loaded magazine up into the magazine well and check to see that it is securely held in place by the magazine catch by pulling down on the magazine as described above. The Carbine may now be fired by switching the safety from SAFE to FIRE.

DISASSEMBLY

Disassemble your Carbine using the following steps:

!! **WARNING: BEFORE YOU BEGIN DISSASSEMBLY OF YOUR CARBINE, YOU MUST FIRST INSPECT IT TO MAKE SURE THERE IS NOT A MAGAZINE IN THE MAGAZINE WELL, THE CHAMBER IS EMPTY, AND THE SAFETY SELECTOR IS ON SAFE.**

MAGAZINE WELL & FIRING ASSEMBLY

Remove the magazine well by unscrewing the three take-down screws from the right side as shown in (fig 5.) and then detaching the magazine well and firing assembly together from the receiver. You may now pull the magazine well forward off of the firing assembly and exchange it if desired.

BUTTSTOCK ASSEMBLY

ONLY AFTER YOU HAVE placed the safety selector on SAFE, removed the magazine from the magazine well, checked to ensure that the chamber is empty, and placed the bolt in the forward position on an empty chamber, you may remove the buttstock assembly. Ensure that the receiver is held securely and the buttstock is in the extended and locked position (See fig 5.). Use a Castle nut wrench to loosen the Castle nut (turning it counter clock-wise when viewed from the rear), turning it until it reaches the rear portion of the threads on the tube. After the Castle nut is loose from the receiver plate, carefully pull the receiver plate backward off of the receiver, completely disengaging it from the receiver. (See fig 5.)

Fig 5.

Once you have accomplished these steps, you may then unscrew the buttstock assembly from the receiver (turning it counterclockwise when viewed from the rear).

!! **WARNING: THE BUFFER SPRING AND BUFFER ARE UNDER COMPRESSION AND WILL COME OUT WITH FORCE. YOU MUST TAKE CARE, USING EXTREME CAUTION, WHEN YOU UNSCREW THE BUTT STOCK ASSEMBLY AND REMOVE IT FROM THE RECEIVER.**

BOLT ASSEMBLY

Once you have removed the buttstock, pull the bolt handle rearward to the bolt handle take-down hole. (See Fig 6.) Loosen the Bolt Handle Screw with a hex wrench; pull the screw and bolt handle straight out of the bolt and receiver as a unit. With the bolt handle removed, the bolt may be taken out by pulling it rearward and out of the receiver.

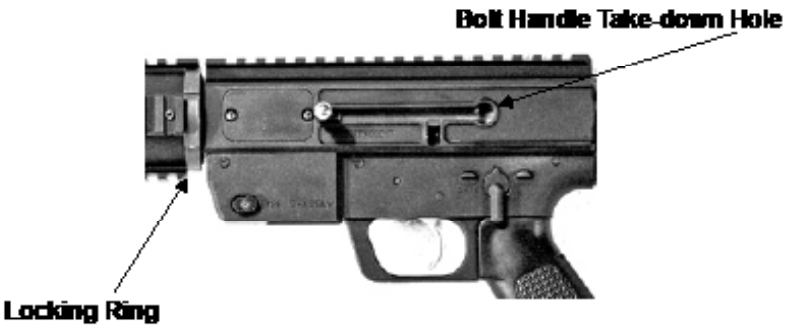

Fig 6.

Disassemble the bolt by twisting the bolt extension ninety degrees in relation to the bolt to unlock it from the bolt, then pull the two apart. Pull the firing pin retainer out of the bolt, followed by the firing pin and firing pin spring (See Fig 7.)

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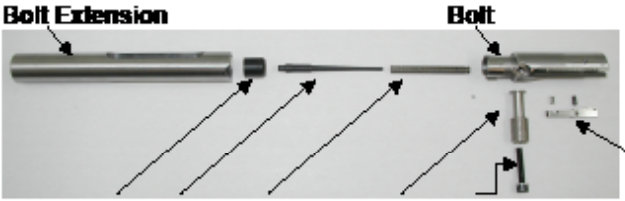


Fig 7.

FOREND

The forend on the J R Carbine is mounted on the barrel nut and locked in place with the locking ring. (See fig 6.)

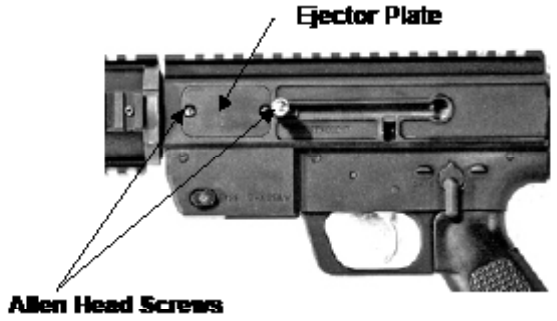
With the receiver held securely in place, tap the locking ring loose (turning it counterclockwise when viewed from the rear) using a locking-ring wrench or soft, non-marring punch. With the locking ring loose, remove the forend (turning it clockwise when viewed from the rear). You may need to use a soft mallet to break it loose if it is more than hand tight.

BARREL ASSEMBLY

With the forend removed, you may now remove the barrel nut by using a barrel nut wrench. Securely place the wrench on the nut, carefully apply force (turning it counterclockwise when viewed from the front) and remove the barrel nut. After the barrel nut has been removed, you may remove the barrel from the receiver by pulling it forward out of the receiver.

RECEIVER ASSEMBLY

The ejector is unique in that it is a fixed machined component of the ejector plate (Patent Pending, Pat. Appl. No. 61302172). You may remove the ejector plate by removing the allen (hex) head screws on either side of the port, and with a small tap from the inside as needed once the screws are removed. The ejector plate may be installed on the opposite side of the receiver for opposite side ejection as long as you also reconfigure the bolt accordingly. (See section entitled "Changing Direction Of Ejection", page 21)



CHANGING DIRECTION OF EJECTION

A unique feature of the JR Carbine is that it is truly ambidextrous and can be set up for either right-side or left-side ejection as the shooter desires. To change ejection direction all you have to do is switch the ejector from one side of the bolt to the other.

With the bolt assembly removed from the receiver, drive the 3/32x1/4-inch extractor pin out of the bolt using a 1/16-inch or 3/32-inch punch. Keep the pin and set it aside.

Next, carefully slide the extractor – along with its spring – out of its slot in the side of the bolt. Take care not to lose the extractor spring when you remove the extractor.

Turn the bolt on its side so that the opposite slot is facing upward. Carefully place the extractor spring in the slot in the proper location (so that it lines up with the indented area of the extractor when the extractor is installed.

Place the extractor into the slot so that the hole in the extractor lines up with the extractor pin holes in the bolt AND the extractor spring indent properly fits over the extractor spring. Push down on the extractor gently to ensure you have spring tension on the extractor spring.

With the extractor properly positioned and the holes in the extractor and bolt properly aligned, insert a punch or allen wrench through the holes to maintain alignment while you prepare to insert the extractor pin.

Gently tap the extractor pin into the bolt from the underside using a small punch and small hammer. The pin is properly installed when it is centered on the extractor.

Test the installation by pressing inward on the back of the extractor. It should resist with spring pressure and should return to its original position when released.

REASSEMBLY

Install the ejector plate on the side of the receiver opposite that on which the extractor is installed in the bolt. Insert the ejector plate into the fitted opening. Install the two allen head screws.

! **CAUTION.** Be careful not to over tighten the allen head screws.

ASSEMBLING THE BARREL AND FOREND

With the receiver assembly held securely, install the barrel assembly by inserting the barrel into the front of the receiver in alignment with the pin in the receiver. Screw the barrel nut into place clockwise and tighten securely. Screw the forend lock ring down over the barrel nut so that its back face is flush with the back face of the barrel nut. The forend is then screwed down as far as possible ending with the top picatinney rail in alignment with the receiver rail. Final alignment can be achieved by visual alignment or through clamping of the two rails together and tightening of the locking ring. Use a spanner wrench or soft drift punch when tightening the locking ring in a clockwise direction (facing from the rear).

ASSEMBLING THE BOLT

Assemble the bolt by inserting the firing pin spring, followed by the firing pin and it's retainer into the bolt. **(NOTE: One end of your firing pin spring may be smaller in diameter than the other. If so, insert the firing pin into the LARGE end of the spring when re-assembling the bolt.)** Attach the bolt extension to the rear of the bolt by aligning the slot in the extension with the bolt handle hole on the side of the bolt and pushing the two together. Then twist the bolt extension ninety degrees to lock it to the bolt. (See Fig 7)

Before inserting the bolt into the receiver, spray a coating of Slip 2000 gun lubricant on the exterior of the bolt and allow it to dry completely. Insert the bolt into the receiver assembly from the back. Rotating the bolt assembly slightly aids in bringing it forward alongside the hammer (if the firing assembly is installed on the receiver). Using any handy item such as a punch to depress the hammer (if necessary), and slide the bolt forward over the hammer. You may need to rotate it slightly until the bolt handle hole in the bolt lines up with the take-down hole in the receiver. When they are aligned, insert the bolt handle into the side of the bolt, and tighten the bolt handle screw with an allen wrench.

!! **WARNING: THE BOLT HANDLE SHOULD ALWAYS BE INSTALLED SO THAT IT IS ON THE OPPOSITE SIDE OF THE RECEIVER FROM THE EJECTION PORT. Failure to do so can result in combustion gases and unburned propellant particles being blown out of the charging handle slot on the side of the receiver opposite the ejection port, potentially causing severe injury to the shooter's face and eyes.**

ASSEMBLING THE BUTTSTOCK

First ensure that the nylon disc is in the tube, followed by the spring capped by the buffer. (Note: the rubber Bumper remains in the back of the buffer tube unless manually removed.) Placing the face of the buffer against the back of the bolt extension and compressing the spring into the tube by pushing the buttstock forward against the receiver begin screwing the buttstock onto the receiver. Continue screwing the buttstock onto the receiver until it cannot be tightened any further. Back the buttstock off of the receiver by unscrewing until you have alignment established between the receiver plate and the receiver. Move the receiver plate forward against the receiver ensuring that the receiver plate and receiver mate together and tighten up the castle nut against the receiver plate. Snug the castle nut in place with the use of a castle nut wrench.

ASSEMBLING THE MAGAZINE WELL AND FIRING ASSEMBLY

The magazine well is installed onto the stud of the forward face of the firing assembly and together they are mounted onto the studs of the receiver. Once in place the take-down screws are inserted into their respective holes and tightened into place.

REASSEMBLY CHECK

With the Carbine pointed in a safe direction the bolt handle should be cycled forward and backward and locked into the bolt catch. The motion should be complete in both directions with the bolt coming all the way forward to the barrel face and the handle backward far enough for the bolt handle to be engaged into the bolt catch, but not back to the take-down hole.

INTERCHANGING CALIBERS

The J R Carbine can be changed from one caliber to another by removing the barrel, bolt, and magazine well and exchanging them with matching components for another caliber cartridge. The process is accomplished by following the instructions described for disassembly and assembly. YOU must ensure that the proper components are exchanged for the caliber and magazine you will use. Ensure that the components all have the correct and corresponding markings for the caliber and magazine.

!! **WARNING: ALWAYS VISUALLY INSPECT YOUR J R CARBINE AFTER CONVERTING IT AND REASSEMBLING IT. IF YOU CONVERT YOUR JR CARBINE TO ANOTHER CALIBER, YOU MUST VISUALLY INSPECT IT TO ENSURE THAT THE BARREL, THE MAGAZINE WELL, AND THE BOLT ARE ALL DESIGNATED FOR THE SAME CALIBER BEFORE YOU FIRE THE CARBINE AGAIN FOR ANY REASON. IF YOU FAIL TO FOLLOW THIS RULE YOU OR OTHERS MAY SUFFER SERIOUS INJURY OR DEATH AS A RESULT.**

CLEANING

Your Carbine should be cleaned by brushing the barrel bore and chamber with a good powder removing solvent and bore brush. After using a bore brush and solvent swab out the bore and chamber with a proper bore rod and patches until the patches come out clean. After cleaning push a clean patch saturated with gun oil through the bore followed by a clean dry patch.

The bolt, bolt extension, receiver, and ejector plate should be disassembled and cleaned in a similar manner. **Lubricate them with Slip 2000 prior to reassembly.**

NOTE: Your J R Carbine has been test fired by the manufacturer before being shipped. As a result you may notice a slight amount of normal post-firing residue remaining within the Carbine's mechanism.

DISCLAIMER OF LIABILITY

ATI and the manufacturer shall not be responsible for product malfunctioning or for physical injury, death or damage to property resulting from either intentional or accidental discharge of this firearm, its criminal or negligent use, improper or careless handling, unauthorized modifications or alterations, use of defective or improper or hand-loaded or reloaded ammunition, or from its use for purposes or subjection to treatment for which it was not designed. Neither ATI, nor the manufacturer will honor claims made by subsequent owners of the firearm.

LEAD EXPOSURE WARNING

!! **WARNING: POTENTIAL LEAD EXPOSURE. Discharging firearms in poorly ventilated areas, cleaning firearms or handling ammunition may result in exposure to lead and other substances known to cause birth defects, reproductive harm and other serious physical injury. Have adequate ventilation at all times. Wash your hands thoroughly after exposure. Shooting or cleaning guns may expose you to lead.**

J R CARBINE PARTS LIST

Buttstock Assembly

Bumper | Disc | Buffer Spring | Buffer

Castle Nut | Receiver Plate

Receiver Assembly

Barrel Nut | Barrel Ring | Locking Forend

Bolt Extension | Firing Pin | Firing Pin Retainer | Firing Pin Spring | Bolt | Bolt Handle & Screw | Extractor | Extractor Spring | Extractor Pin

Firing Assembly

Take-down Screws

Magazine Well

ATI Warranty Service Policy & Procedure ATI 2 year limited warranty.

American Tactical Imports provides warranty services, parts and repairs for all of our products. If you believe your ATI imported product or ATI brand product needs service or replacement, please contact 1-800-290-0065 or email techservice@americantactical.us. One of our representatives will assist you and provide all instructions.

If you are contacting ATI for service of a firearm please have your serial number available. All returns for service or repair require a **Return Authorization (RA)** number to be issued by an ATI representative. **No returns for service will be accepted without an ATI issued RA number written clearly on the outside of the package.** Any items received without an ATI issued RA number will be returned to the sender without action.

Service time may vary due to work load and availability of parts from manufacturers. It is the responsibility of the consumer to ship any firearms or products to ATI for service. All firearms must be registered by mail in registration form or online registration before an ATI representative can issue a return authorization number.

If an item received is outside of warranty coverage, an ATI representative will contact you before further action is taken.

The warranties covered by ATI are implemented and monitored by manufacturers of all ATI products. ATI reserves the right to deny or decline any warranty services or products that do not meet the warranties implemented by our manufacturers.

If you are returning a rifle or shotgun for service, you may ship to ATI via US Postal Service or any parcel delivery service directly to ATI.

If you are returning a pistol, it is the responsibility of the owner to contact a local FFL holder to ship to ATI. All warranty service information must be provided by the FFL holder who is shipping the pistol.

All firearms returned to ATI for service can only be shipped back to the original senders address. Change of return shipping address once received is not authorized. Pistols can only be shipped to and from FFL locations.

If you have any questions or concerns regarding ATI's warranty policy or services please contact us at 1-800-290-0065 or email at customerservice@americantactical.us.